

42-113

Dart Aerospace Ltd.

29/04/2009 10:15:11 AM

Process Sheet

CU-DAR001 Dart Helicopters Services	Drawing Name	: SKIDTUBE ASSEMBLY, 206 A/B LOW
: 47583A		
Number : 13807	Part Number	: D206642151
Number :	Drawing Number	: D3804 REV.A
This Issue : 29/04/2009 S.O. No. :	Project Number	: N/A
Prsht Rev. : NC	Drawing Revision	: A
First Issue : // Type : SKIDTUBES	Material	:
Previous Run : 46562A	Due Date	: 15/05/2009 Qty: 1 Um: Each
Written By :		
Checked & Approved By : <u>JW 09.04.29</u>		
Comment :		
Est Rev:A 09-03-06 new issue DD verified by:EC		
Est Rev:B 09-03-10 add sub assembly D206-642-149 DD verified by:EC		
Est Rev:C 09-04-06 replace -147 as per ECN09-549 DD verified by:EC		

Additional Product

Job Number:



Seq. #: Machine Or Operation: Description :

1.0 DC DOCUMENT CONTROL



Comment: DOCUMENT CONTROL

Photocopy bluefile & type labels per PPP D206-642-151 CHG001

N/A

2.0 D2620 Skidtube, 206 Skidtube



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

Pick:

Qty Part Number Description Batch

1 D2620 Bent Tube 3" OD

45896

ET 09-05-07

3.0 D32861 Doubler



Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)

Pick:

Qty Part Number Description Batch

2 D3286-1 Doubler

46440
B44286

ET 09.05.07

4.0 D2647 Cap



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

Pick:

Qty Part Number

1 D2647

Description Batch

Fwd Cap

243846

ET 09/05/07

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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NOTE: Date & initial all entries

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User: Julie Dawson

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Customer: CU-DAR001 Dart Helicopters Services

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Job Number: 47583A

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Job Number:



Seq. #:

Machine Or Operation:

Description :

5.0

SKIDTUBES 1

SKIDTUBESS RESOURCE 1



Comment: LANDING GEAR RESOURCE 1

1-Deburr Fwd edge of tube

2- Remove ridge on inside of Fwd edge of tube as per Dwg D3804

} JE 09-05-07

3-Weld Fwd Cap as per Dwg D3804. Use aluminum rod. Grind D2647 to fit as required.

Pick:

Qty Part Number Description Batch

A/R Aluminum Rod

M110972/M109213

JE 09/05/07

4-Grind weld flush to cap on top surface only.

JE 09/05/07

5-Cut Aft end as per dwg D3804 from front of tube and Deburr

6-Remove inner indexing ridge on Aft end of skidtube as per Dwg D3804

7-Open holes for Aft end cap as per Dwg D3804 with #30 Drill Bit using DT8025.

8-Drill pilot holes using Dt 8166 (A,B & C).

9-Locate DT8732 from inner Aft saddle hole & 3rd crossbolt hole. Insert D3286-1 doubler using DT8732 & D206-642-241-T1, then locating doubler off of 3/16" holes, cleco DT8732 & doubler leaving DT8732 for added support.

10- Drill D3286-1 doubler rivet holes in tube using # 40 drill, spot drilling doubler at the same time.

JE 09-05-07

11-Working from the center out, drill # 30 holes into D3286-1 doubler. Cleco each hole as it is being drilled. Verify angle of holes to accommodate rivet heads.

12-Remove and Deburr D3286-1 doubler

13-Remove 3/16" cleco's only and open GHW holes to Ø0.500" as per Dwg D3804

14-Remove D3286-1 doublers, identify orientation, deburr, then attach them to the workorder

15-Remove indexing edge using DT8741 as per Dwg D3804

16-C'sink GHW rivet holes as per Dwg D3804

W/O:		WORK ORDER CHANGES					
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Job Number:



Seq. #:

Machine Or Operation:

Description :

6.0

QC6

DIMENSIONAL CHECK



Comment: DIMENSIONAL CHECK

09/05/08 (4)

7.0

SKIDTUBES 1

SKIDTUBESS RESOURCE 1



Comment: LANDING GEAR RESOURCE 1

1-Open crossbolt holes to 0.3125"

2-Open Aft cap hole #6.

****no wearplate holes for this skidtube****

3-Deburr tube and blow out chips from inside the tube

IT 09-05-08

8.0

HAND FINISHING1

HAND FINISHING RESOURCE #1



Comment: HAND FINISHING RESOURCE #1

Chemical Conversion Coat as per QSI 005 4.1

IT 09-05-08

9.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

ID M 9-5-8

10.0

SKIDTUBES 1

SKIDTUBESS RESOURCE 1



Comment: LANDING GEAR RESOURCE 1

1-Open holes to finished size as per Dwg D3804, (without cutting fluid)

2-C'sink crossbolt spacer holes as per Dwg D3804(without cutting fluid)

3-Deburr and blow out all chips from inside the tube

BE 9-5-11

11.0

QC6

DIMENSIONAL CHECK



Comment: DIMENSIONAL CHECK

09/05/11 (4)

W/O:		WORK ORDER CHANGES					
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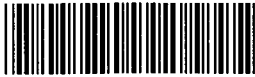
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Job Number: 47583A

Part Number: D206642151

Job Number:



Seq. #:	Machine Or Operation:	Description :
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12.0	CR3212404	Cherry Rivet
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Comment: Qty.: 52.0000 Each(s)/Unit Total : 52.0000 Each(s)

Pick:

Qty Part Number Description Batch

52 CR3212-4-04 Rivet M11127 (69) BE 09-05-11

13.0	D26541	Web
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Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

Web

batch: 347680 BE 09-05-11

14.0	SKIDTUBES 1	SKIDTUBESS RESOURCE 1
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Comment: LANDING GEAR RESOURCE 1

1-Locate, install and rivet doublers as per Dwg D3804. Micro-shave rivets as required BE 09-05-11

2-Bond D2654-1 web in place as per QSI 015. Ensure holes line up. Allow 12 Hrs. cure time before cutting

Start Date: 09-05-11 Time: 2:00

Finish Date: 9/5/12 Time: 8:15am BE 09-05-11

Pick:

Qty Part Number Description Batch

A/R Sikaflex-291 M11081

Sikaflex expire date: 01/2010

15.0	QC5	INSPECT WORK TO CURRENT STEP
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Comment: INSPECT WORK TO CURRENT STEP

Sorlos 12 (R)

16.0	D2649	Cross Bolt Spacer
------	-------	-------------------



Comment: Qty.: 19.0000 Each(s)/Unit Total : 19.0000 Each(s)

Pick:

Qty Part Number Description Batch

19 D2649 Crossbolt spacer 845317 BE 09-05-12

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

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Part Number: D206642151

Job Number:



Seq. #: Machine Or Operation: Description :

17.0 D32863 Spacer



Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)

Pick:

Qty Part Number Description Batch

2 D3286-3

Spacer

B43862

BE 09/05/12

18.0 SKIDTUBES 1 SKIDTUBESS RESOURCE 1



Comment: LANDING GEAR RESOURCE 1

1-Prep per QSI 005 and Insert D2649 crossbolt spacers. Weld as per QSI 004 and Dwg D3804. Remember to back drill each hole to 0.25" before welding the other side. Use aluminum rod.

Pick:

Qty Part Number Description Batch

A/R Aluminum Rod

m109213

BE 09/05/12

2-Grind welds flush as per Dwg D3804.

3-Using DT8733, insert (2) D3286-3 spacers as per QSI 004 and Dwg D3804. Remember to back drill each hole to Ø0.402" before welding other side. Use SS rod as required.

A/RSS Rod

NONE

BE 09/05/12

4-Counterbore 5/16" x 0.750" deep except 7th hole from Aft end as per Dwg D3804. Deburr

19.0 CCR264SS33 Cherry Rivet



Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)

Pick:

Qty Part Number Description Batch

2 CCR264SS3-3 Rivets

m111548

pm 09-05-13 *(2)*

20.0 CR3212403 Cherry Rivet



Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)

Cherry Rivet

batch: *m111359*

pm 09-05-13 *(2)*

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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Job Number: 47583A

Part Number: D206642151

Job Number:



Seq. #:

Machine Or Operation:

Description :

21.0

D2680041

Nut Plate



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

Pick:

Qty Part Number Description Batch

1 D2680-041 Nut Plate

1533061

Pm 09-05-13 (C)

22.0

HAND FINISHING1

HAND FINISHING RESOURCE #1



Comment: HAND FINISHING RESOURCE #1

Install D2680-041 Nut Plate as per Dwg D2650

Pm 09-05-13 (C)

23.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: Counterbore work to Current Step . Inspect for foreign objects as per QSI 024

509/05/13 (X)

24.0

QC10

VISUAL INSPECTION OF GROUND WELDS



Comment: VISUAL INSPECTION OF GROUND WELDS

509/05/13 (X)

25.0

HAND FINISHING1

HAND FINISHING RESOURCE #1



Comment: HAND FINISHING RESOURCE #1

Pressure wash as per QSI 005

BL 09-05-13 (C)

26.0

POWDER COATING

POWDER COATING



Comment: POWDER COATING

Powder Coat White Gloss (Ref. 4.3.5.1) as per QSI 005 4.3. Make sure Nut Plate Thread is protected using paint screw, and mask GHW studs.

(X)

START TIME:

10:15

OVEN TEMPERATURE:

320°

FINISH TIME:

16:45

umy

09/05/15

27.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

BL 09-06-13 (C)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

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Job Number: 47583A

Part Number: D206642151

Job Number:



Seq. #:	Machine Or Operation:	Description :
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28.0

D3805041

Wearplate Assembly Fwd, Low Gear



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

Wearplate Assembly Fwd, Low Gear

* batch: B47723

MD 09/06/03

29.0

D3805045

Wearplate Assembly Aft, Low Gear



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

Wearplate Assembly Aft, Low Gear

* batch: B47724

MD 09/06/03

30.0

AN337A

Bolt



Comment: Qty.: 7.0000 Each(s)/Unit Total : 7.0000 Each(s)

Bolt

batch: M105425

MD 09/06/03

31.0

AN960JD10

Washer



Comment: Qty.: 7.0000 Each(s)/Unit Total : 7.0000 Each(s)

Washer

batch: M105442

MD 09/06/03

32.0

MS21042L3

Nut



Comment: Qty.: 7.0000 Each(s)/Unit Total : 7.0000 Each(s)

Nut

batch: M10844

MD 09/06/03

33.0

D38731

Bushing



Comment: Qty.: 14.0000 Each(s)/Unit Total : 14.0000 Each(s)

Bushing

batch: ~~M1084~~ B46757

MD 09/06/03

34.0

AN960JD416

Washer



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

Washer

batch: M108161

MD 09/06/03

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

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Job Number: 47583A

Part Number: D206642151

Job Number:



Seq. #:

Machine Or Operation:

Description :

35.0

D26511

Plug



Comment: Qty.: 6.0000 Each(s)/Unit Total : 6.0000 Each(s)

Pick:

Qty Part Number Description Batch

6 D2651-1

Plugs

B43990

MD 09/06/03

36.0

D26513

O-Ring



Comment: Qty.: 6.0000 Each(s)/Unit Total : 6.0000 Each(s)

Pick:

Qty Part Number Description Batch

6 D2651-3

O-Rings

B43849

MD 09/06/03

37.0

MS27039406

Screw



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

Pick:

Qty Part Number Description Batch

1 MS27039-4-06 Screw

M109061

MD 09/06/03

38.0

HAND FINISHING1

HAND FINISHING RESOURCE #1



Comment: HAND FINISHING RESOURCE #1]

1- install RUN-ON LANDING WEARPLATE KIT as per dwg

2- Install D2651-3 O-Rings on D2651-1 plugs with Petroleum Jelly and install plugs as per Dwg D3804.

Clean excess adhesive.

MD 09/06/03

39.0

D2646

Aft Cap



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

Pick:

Qty Part Number Description Batch

1 D2646

Aft Cap

B46327

MD 09/06/03

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

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Job Number: 47583A

Part Number: D206642151

Job Number:



Seq. #:

Machine Or Operation:

Description :

40.0

MS27039108

Screw



Comment: Qty.: 2.0000 Each(s)/Unit Total: 2.0000 Each(s)

Pick:

Qty Part Number Description Batch

2 MS27039-1-08 Screw M110467

MD 09/06/03

41.0

AN960JD10L

Washer



Comment: Qty.: 2.0000 Each(s)/Unit Total: 2.0000 Each(s)

Pick:

Qty Part Number Description Batch

2 AN960JD10L Washer M109632

MD 09/06/03

42.0

HAND FINISHING1

HAND FINISHING RESOURCE #1



Comment: HAND FINISHING RESOURCE #1

1-Install D2646 Aft Cap and seal with Sikaflex. Clean excess adhesive

A/R Sikaflex-291 M111081

Sikaflex expire date: 10/20

MD 09/06/03

2-Wing Walk as per Dwg D3804 and QSI 005 4.4

Batch: M111013

- FL/SD 09/06/04 0

43.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

S 09/06/04 (X)

44.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

inspect for foreign objects as per QSI 024

S 09/06/04 (X)

45.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and pack for shipping as per PPP D206-642-151

Location:

PPP Rev:

PPP47583

S 09/06/08 (X)

W/O:		WORK ORDER CHANGES					
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Seq. #:

Machine Or Operation:

Description :

46.0

QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

09/06/08

Job Completion



mf
09-06-08

W/O:		WORK ORDER CHANGES					
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NOTE: Date & initial all entries

ITEM	Qty -041	Qty -043	Part Number	Description
1	X		D3804-041	SKIDTUBE ASSEMBLY, 206 A/B LOW
2		X	D3804-043	SKIDTUBE ASSEMBLY, 206 A/B HIGH
5	1	1	D2600-1-160	EXTRUSION
6	1	1	D2646	AFT CAP
7	1	1	D2647	CAP
8	19	20	D2649	CROSS BOLT SPACER
9	6	8	D2651-1	PLUG
10	6	8	D2651-3	O-RING
11		1	D2654-3	WEB
12	1		D2654-1	WEB
13	1	1	D2680-041	NUT PLATE
14	2	2	D3286-1	DOUBLER
15	2	2	D3286-3	STUD
21	2	2	AN960JD10L	WASHER
22	1	1	AN960JD416	WASHER
23	2	2	CCR264SS3-3	RIVET
24	2	2	CR3212-4-03	RIVET
25	52	52	CR3212-4-04	RIVET
26	2	2	MS27039-1-08	SCREW
27	1	1	MS27039-4-06	SCREW

NOTES

- 1) MATERIAL: N/A
- 2) FINISH: -CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
-POWDER COAT WHITE (4.3.5.1) PER DART QSI 005 4.3
- 3) BLACK ANTI-SKID PAINT AS INDICATED TO 0.5 ABOVE LOCATION RIDGE PER DART QSI 005 4.4
- 4) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 5) UNITS: INCHES UNLESS OTHERWISE NOTED
- 6) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 7) IDENTIFICATION: NONE
- 8) WEIGHT: 12.5 lb
- 9) WELD PER DART QSI 004
- 10) BENDING: DAMAGE TOLERANCE ON FWD BEND:
THERE SHOULD BE NO VISIBLE WRINKLES IN THE BEND FROM THE GROUND TO A HEIGHT OF 5 INCHES ABOVE THE GROUND. IT IS ACCEPTABLE TO POLISH OUT GOUGES UP TO 0.020 DEEP IN THE BENT PORTION OF THE TUBE. A MAXIMUM REDUCTION IN DIAMETER OF 0.150" IS ACCEPTABLE IN THE BENT PORTION OF THE TUBE.
- 11) BOND WEB INTO OUTER TUBE WITH SIKAFLEX-241/-291 ADHESIVE PER DART QSI 015
- 12) INSERT D2651-1 PLUG C/W D2651-3 O-RING IN HOLES MARKED 'P' (BOTH SIDES OF TUBE)

RELEASED
UP 09-03-03
per ECN 09-530

A	NEW ISSUE	MB	08.07.07
REV.	DESCRIPTION	BY	DATE
DESIGN	97	DART AEROSPACE USA, INC	
DRAWN	97	PORT HADLOCK, WA	
CHECKED	97	DRAWING NO.	REV. A
MFG. APPR.	97	D3804	SHEET 1 OF 5
APPROVED	97	TITLE	SCALE
DE APPR.	97	SKIDTUBE ASSEMBLY, 206A/B	NTS
DATE	08.07.07	<small>COPYRIGHT © 2008 BY DART AEROSPACE USA, INC THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE USA, INC.</small>	

NO. 477589A
WORK ORDER
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RETURN TO
SHOP COPY

09.03.03



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A
WORK ORDER
NO. 47583A

Technical drawing of a mechanical part, likely a shaft or pipe, showing dimensions and details. The drawing includes a top view with a curved end and a side view with a flange. Key dimensions include a total length of 104.1, a bend radius of R30.0±1, and various hole diameters and positions. Details A and B are indicated for specific areas of the part.

Dimensions:

- Overall length: 104.1
- Distance from end to bend tangent: 87.0
- Bend radius: R30.0±1
- Distance from end to first hole: 17.1 REF
- Distance between holes: 15.450, 14.87, 6.500, 21.00^{+0.030}_{-0.000}
- Hole diameters: Ø0.375 THRU 20 PL, Ø0.375
- Flange thickness: 7.00 FLAT
- Distance from end to flange: 10.00
- Distance from flange to end: 15.50
- Distance from end to last hole: 5.00
- Distance from last hole to end: 2.00 TO WEB

Details:

- DETAIL A C7-5
- DETAIL B C5-5

Other Labels:

- D2654-3 WEB
- NO CBORE THIS HOLE ON EITHER SIDE
- 10 5.0
- 11

Technical drawing of a ship's hull section showing the transition from a curved bow to a straight hull. The drawing includes various dimensions and labels for construction details. Key features include:

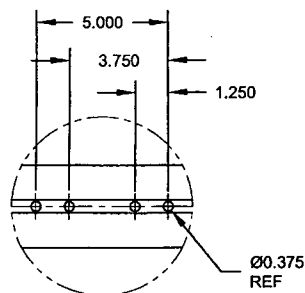
- MASK THREADS IN D2680-041 BEFORE APPLYING FINISH REF DETAIL E**: Label for the bow area.
- DETAIL E A7-5**: Detail callout for the bow's edge.
- FINISH HOLES PER SECTION D-D**: Label for the hull surface.
- ANTI-SKID PAINT 3 PL**: Label for the hull surface.
- D**: Label for the deck.
- A6-5 D**: Label for a specific deck area.
- DETAIL F B2-5**: Detail callout for the stern area.
- Dimensions**: 1.5, 12.0, 0.5, 15.5, and 1.5.
- Section Line**: D-D.

DESIGN	99	DART AEROSPACE USA, INC	
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CHECKED	99	DRAWING NO.	REV. A
MFG. APPR.	EE	D3804	SHEET 3 OF 3
APPROVED	140	TITLE	SCALE
DE APPR.	140	SKIDTUBE ASSEMBLY, 206A/B	NT
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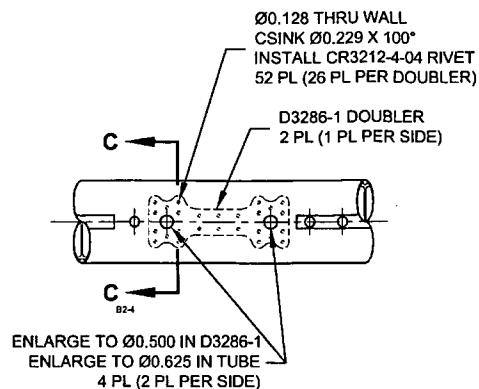
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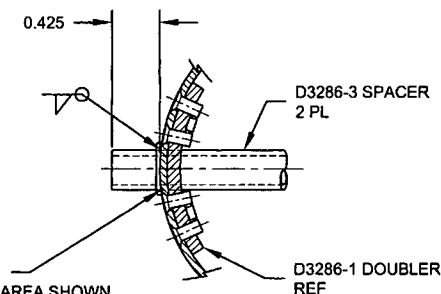
DETAIL A
SCALE NONE

D6-2
C2-2
D6-3
C2-3



DETAIL B
SCALE NONE

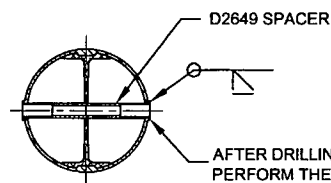
C3-2
C3-3



- TO INSTALL D3286-1/3:
1. GRIND OFF FLANGE IN AREA SHOWN, FLUSH WITH OUTSIDE SURFACE OF ROUND TUBE
 2. LOCATE & DRILL D3286-1 DOUBLER USING DT3286-1T1
 3. ENLARGE HOLES IN D3286-1 TO Ø0.500
 4. ENLARGE HOLES IN TUBE TO Ø0.625 AND CHAMFER HOLE 0.03 X 45°
 5. RIVET D3286-1 TO TUBE
 6. INSERT D3286-3 SPACER
 7. WELD IN PLACE AND GRIND FLUSH

SECTION C-C
PARTIAL SECTION
SCALE NONE

C6-4



- AFTER DRILLING AND BENDING ASSEMBLY PERFORM THE FOLLOWING FOR Ø0.375 HOLES ONLY:
1. CHAMFER HOLE 0.03 X 45°
 2. INSERT D2649 SPACER
 3. WELD INTO PLACE AND GRIND FLUSH
 4. CBORER TO Ø0.313 X 0.75 DP (EXCEPT WHERE INDICATED)

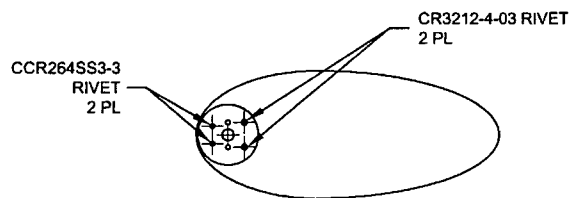
SECTION D-D
FOR Ø0.375 HOLES ONLY
SCALE NONE

A4-2
A4-3

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MFG. APPR.	91	D3804	SHEET 4 OF 5
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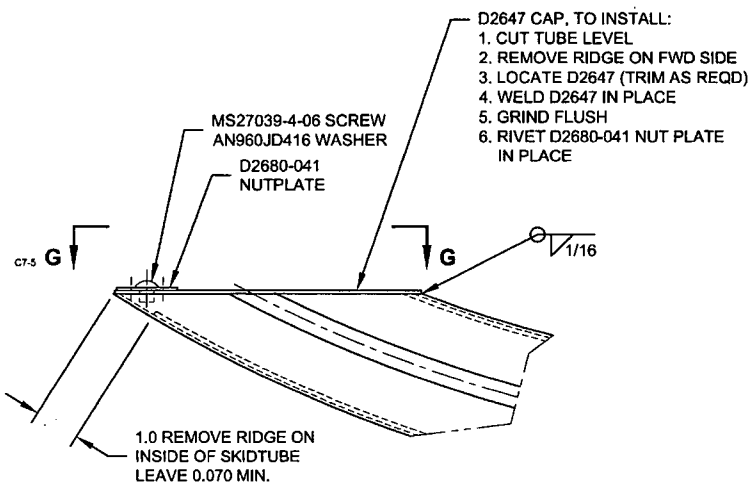
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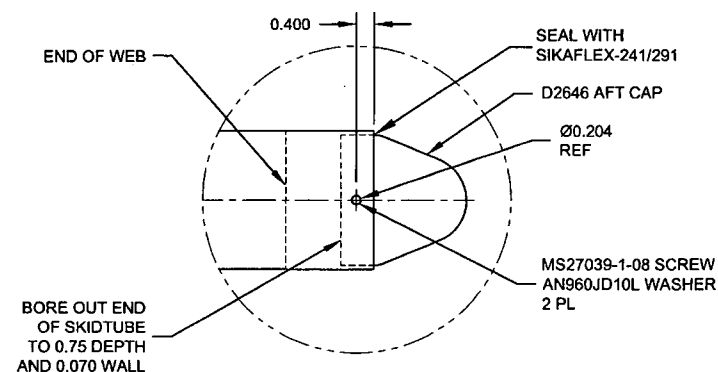
VIEW G-G
SCALE NONE

A7-5



DETAIL E
SCALE NONE

B7-2
B7-3



DETAIL F
SCALE NONE

B2-2
B2-3

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CHECKED	91	DRAWING NO.	REV. A
MFG. APPR.	91	D3804	SHEET 5 OF 5
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DE APPR.	91	SKIDTUBE ASSEMBLY, 206A/B	NTS
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NO. 198

AWS D17.1.2001
QUALIFICATION TEST RECORD

Name: Barclay Elliott
Job number: 47288A
Part number: D206 612 545
Description: 206 skid tube
Welding Process: Tig ☒ Mig ☐
Base material: Aluminium
Current: AC ☒ DC ☐

TEST REQUIREMENTS AND RESULTS

Visual:
Penetration:

pass ☒ fail ☐
pass ☒ fail ☐

UNACCEPTABLE

Cracks:
Undercut:
Pin holes:
Overlap (cold lap)
Porosity (surface):
Coloration:

pass ☒ fail ☐
pass ☒ fail ☐
pass ☒ fail ☐
pass ☒ fail ☐
pass ☒ fail ☐
pass ☒ fail ☐

Qualifier P. D. [Signature] Date of Test Coupon 09.04.27

Welder Barclay Elliott Date of Test Coupon 09.04.27

The above named individual is qualified in accordance with AWS D17.1.2001 to weld